

Date • Wednesday, 15/08/2007 3:47:15 PM
User Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 6" MIRROR
Job Number	: 33916		
Estimate Number	: 10101		
P.C. Number	: <i>N/A</i>	Part Number	: D2011101
This Issue	: 15/08/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2011 REV. F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: F
Previous Run	: 30376	Material	: <i>N/A</i>
Written By	: <i>W</i>	Due Date	: 30/08/2007 Qty: 40 Um: Each
Checked & Approved By	: <i>W</i>		
Comment	: Est: J 04.09.15 Added Steps 5-7 KJ/JLM Est: K 05.12.15 chg black sikaflex for white EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: *4370*
Purchase Grote Mirror P/N: 28043
Possible supplier: *UAP/NAPA*
Material release note required

C207108/14
(40)

2.0	28043	MIRROR 6"
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)
Mirror 6"

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage
Ensure Material Release Note is attached

7/8/22 SP (40x)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

counter
EP A102/06 (40)

5.0	D30141	Locknut
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)
Locknut
Pick:
Qty Part Number Description Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 3:47:15 PM

User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 6" MIRROR

Job Number: 33916

Part Number: D2011101

Job Number:



Seq. #:

Machine Or Operation:

Description:

1 D3014-1

Lock nut

D18605

6.0

AN960JD416L

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD416L Washer

Batch

M105078 (34)

M105408 (67)

9/07/09/1040

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Discard Hardware & Install new hardware loosely

Sad

07-09-25

(39)

2- Drill mirror using drill Jig DT8704 as per Dwg D2011

SAD

07-09-25

(39)

3- Inject 3ml of Sikaflex -291/-241 adhesive per hole.

Qty Part Number Description Batch

9ml N/A

Sikaflex-291/-241

Batch

M105488

Expiry date

07/10/08

Start:

07/10/01

Time:

7h10

Finish:

07/10/01

Time:

10h45

SAD

07/10/01

P18

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4- Test assembly to 50lbs pull test after 24 hours

07/10/10

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

07/10/10 (39)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20/11/11

Job Completion



W 8-10/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

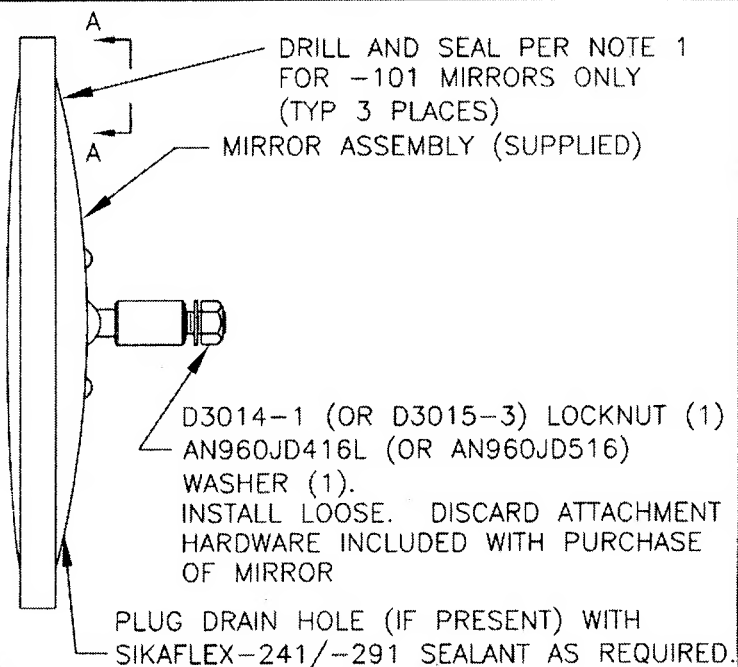
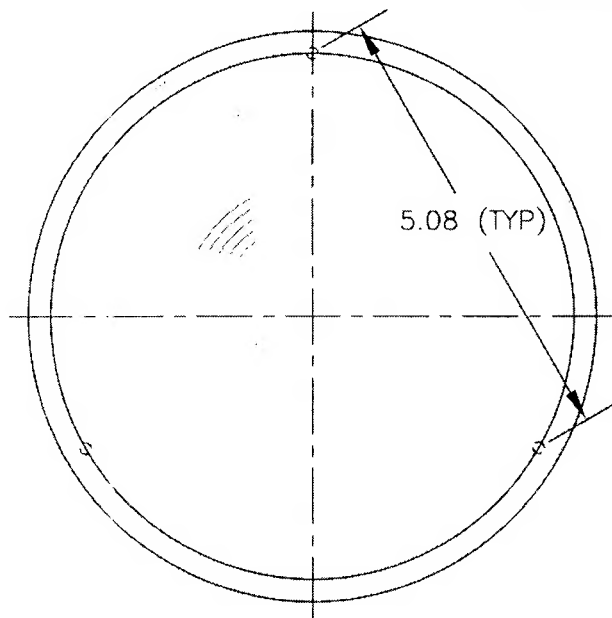
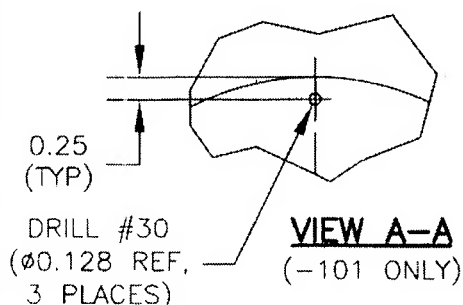
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/25	#	One mirror was broken while drilling holes i.e. Human error	<i>[Signature]</i> Desai	Scrap and Destroy No Replce	SAD 07-09-25	<i>[Signature]</i> 07-10-10	<i>[Signature]</i> Desai	Ev 07/25

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2011	REV. F SHEET 1 OF 1
DATE 04.09.10	TITLE MIRROR ASSEMBLY		SCALE 1:2
-	90.03.31	NEW ISSUE	
A	90.06.15	DWG No. WAS DSP1011, ADDED -103	
B	98.04.09	SIKAFLEX 241 ADDED	
C	99.06.01	REPLACE DOMINION AUTO MIRRORS WITH PHILLIPS, ADDED STUDS, REDRAWN	
D	01.04.23	NEW 6" MIRROR, ADD NUT, RMV STUD	
E	01.05.08	NEW 8" MIRROR	
F	04.09.10	ADD HOLES FOR SEALANT ON -101	



QTY -101	QTY -103	Part Number	Description
X		D2011-101	MIRROR ASSEMBLY 6"
	X	D2011-103	MIRROR ASSEMBLY 8"
1		28043	MIRROR 6" (GROTE)
	1	708441	MIRROR 8" (VELVAC)
1		D3014-1	LOCKNUT
1		AN960JD416L	WASHER
	1	D3015-3	LOCKNUT
	1	AN960JD516	WASHER

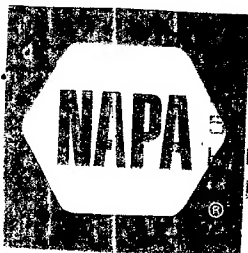
NOTES:

- 1) ON -101 MIRRORS ONLY, DRILL QTY(3) Ø0.128 HOLES (REF) AS SHOWN AND INJECT SIKAFLEX-241/-291 SEALANT TO ENSURE MIRROR ADHERES TO HOUSING. TEST ASSEMBLY TO 50 LBS AFTER 24 HOURS.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

W/O: 33916

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WILKESBURY AUTO PARTS INC 5580GST#:
54 MAIN STREET WEST
WILKESBURY, ONT. K6A 2J2
TEL: 632-8575 FAX: 632-1539

861597896RT0001

DANGEROUS GOODS PERMIT
EXPIRY DATE:

EMERGENCY TELEPHONE NUMBER 24 HOURS
CANUTEC 613-996-6666

ACCT #	SOLD TO	DATE	TIME	STORE #	EMP #	INVOICE NO
01531	DART AEROSPACE LTD	8/21/07	13:47	060004074	21	171291
SR #	1270 ABERDEEN STREET	PURCHASE ORDER #				
PO	WILKESBURY, ONTARIO	00004370				
AD	K6A 1K7	TAX EXEMPTION: 6122-5207				
DE		TERMS: NET 30 DAYS CHARGE SALE				
		DELIVERY:				

PART	NUMBER	LN	DESCRIPTION	QUANTITY	PRICE	NET	TOTAL
		GRD	GROTE	40.00			

Subtotal
Tax 6% GST ONLY
Tax 0%

0.00

SIGNATURE

ALL GOODS RETURNED MUST BE ACCOMPANIED BY THIS INVOICE

TOTAL ----> CHARGE SALE

Dart Aerospace Ltd

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613) 632-3336
Fax: (613) 632-4443

Receiving Slip

Date Aug 23, 2007	Page 1
Receipt Number RCP00005433	

Purchase From:

Uap Hawkesbury Inc. #074
514 Main Street West
Hawkesbury, ON K6A 2J2

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Description	Contact	Vendor Number	PO Number
			VC-UAP001	PO00004370

Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Date
	28043	MIRROR 6" GROTE MIRROR P/N: 28043 AS PER DWG D2011 REV. F B/N33916	40.0000	Each	11.000000	440.0000	Aug 23, 2007

Comments:

DART

Purchase Order

Date Aug 16, 2007	Page 1
Purchase Order Number PO00004370	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

FXED
CL

Vendor Address:

Uap Hawkesbury Inc. #074
514 Main Street West
Hawkesbury, ON K6A 2J2
Phone (613) 632-8575
Fax (613) 632-1539

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-UAP001	Aug 16, 2007	N30	yours	Aug 23, 2007

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
40.0000	28043 ✓ <i>2/8/2+ SP</i>	MIRROR 6" Comments: AS PER DWG D2011 REV. F GROTE MIRROR PIN: 28043	8/23/2007	No	XXXXXX	Each	XXXXXX
CERTIFICATE OF CONFORMITY REQ'D UPON DELIVERY							

Comments:

Tax Summary:
GST
GSTME
GSTND

Entered By: *CL* CLAVOIE

Approved By: *W*

Less:
included tax

0.00

Subtotal

Total tax

Total purchase order in

CAD Dollars

Dart Aerospace Ltd

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613) 632-3336
Fax: (613) 632-4443

Receiving Slip

Date Jan 30, 2007	Page 1
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Receipt Number RCP00003628

Purchase From:

Uap Hawkesbury Inc. #074
514 Main Street West
Hawkesbury, ON K6A 2J2

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Description	Contact	Vendor Number	PO Number
			VC-UAP001	PO00002929

Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Date
	28043	MIRROR 6" AS PER DWG D2011 REV. F GROTE MIRROR P/N: 28043	50.0000	Each			Jan 30, 2007
REFERENCE ONLY							

Comments: